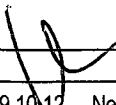
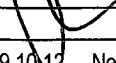


Date: Wednesday, 23/08/2006 11:44:05 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 28259	
Estimate Number : 11055	
P.O. Number : N/A	Part Number : D2884
This Issue : 23/08/2006 S.O. No. : N/A	Drawing Number : D2884 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 21/08/2006 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25982	Material : N/A
Written By : 	Due Date : 28/08/2006 Qty: 40 Um: Each
Checked & Approved By : 	
Comment : Est A 99.10.12 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s)
 Material: 6061-T6 0.080" Thick
 Batch M101178

SAP 06.08.23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

SAP 06.08.23

(50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAP 06.08.23

(50)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

SAP 06.09.06

50

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M

06-09-06

(50)

6.0	QC2	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

INSPECT POWER COAT / CHEMICAL

CONVERTER

24/9/07 (50)

Date: Wednesday, 23/08/2006 11:44:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28259

Part Number: D2884

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 39B

P. 4/9/2 (50)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07 (50)

Job Completion



U 06.09.07

Date: Monday, 8/21/2006 2:11:59 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE SPACER
Job Number :	28259		
Estimate Number :	11055		
P.O. Number :		Part Number :	D2884
This Issue :	8/21/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2884 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	25982	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	8/28/2006
Written By :		Qty:	40
Checked & Approved By :	<i>JA 06.08.21</i>	Um:	Each
Comment :	Est A 99.10.12 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s)
 Material: 6061-T6 0.080" Thick
 Batch _____

we target

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.90" x 4.60" (+0.030" - 0.000")

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2884
 2-Tumble
 3-Deburr any rough edges after tumbling

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28259

Part Number: D2884

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

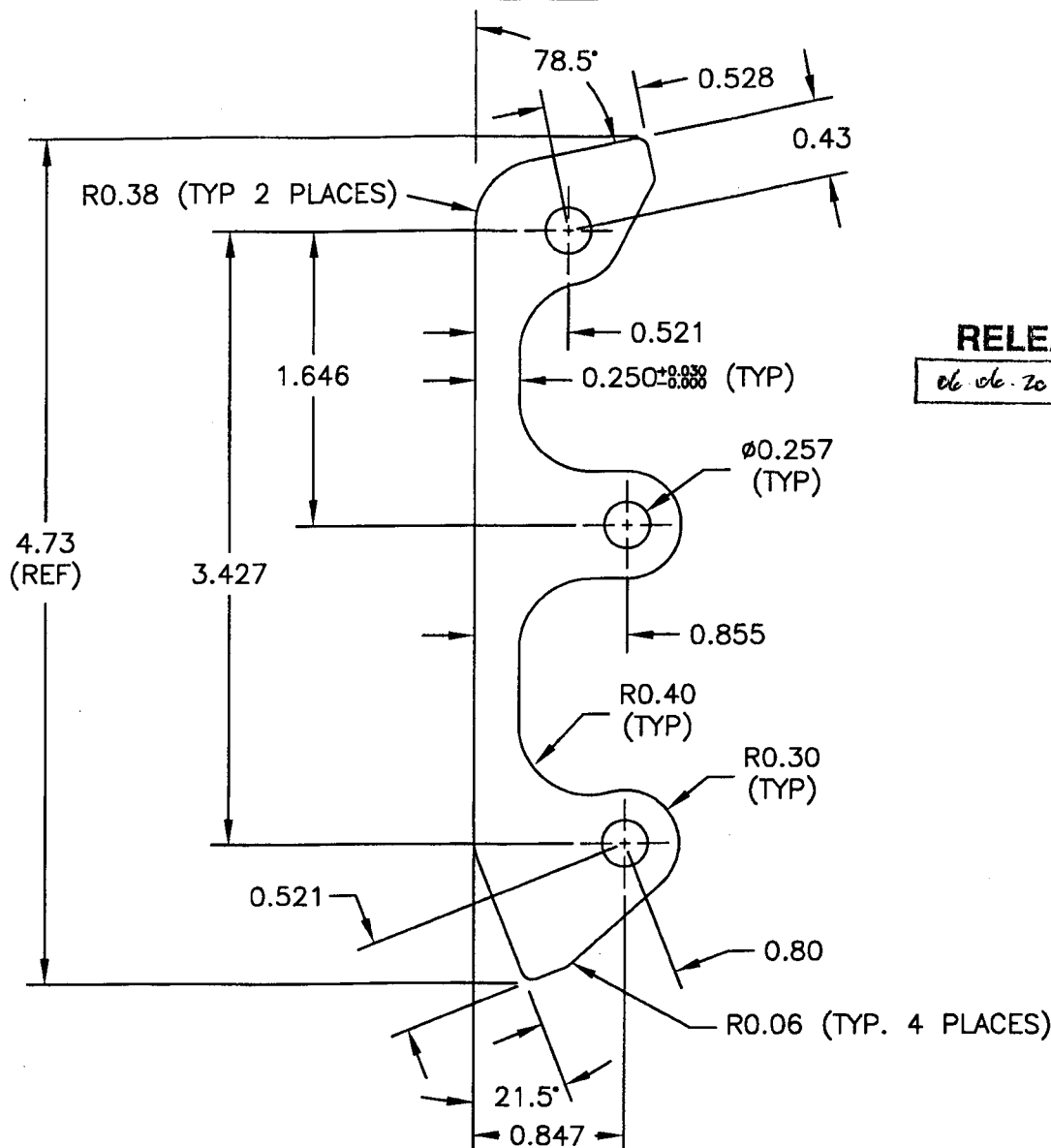
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2884	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



NOTES:

- MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.010 TO 0.020
- ALL DIMENSIONS ARE IN INCHES

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 NO. **28259**

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